

Work Order ID 54302

December 7, 2009 3:07:59 PM

Page 1

Item ID: D3766-1

Revision ID:

Item Name: Front Rail, LF

Start Date: 07/12/2009 Start Qty: 8.00

Required Date: 21/12/2009 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3766

Rev B

100

0.00



Small Fab

Small Fab

Small Fab

Memo

1-cut tube to length as per dwg D3766 2-drill holes thru to finish size as per dwg D3766 using DT9413 DRILL HOLES LABELLED #1 3-deburr

m. l 10/01/12

8X

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

=> 8/01/14

XS

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

SAN 10-01-14

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54302

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Page 2

Item ID: D3766-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Rail, LH

Start Date: 07/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

SK

10-01-14

(B)

A



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: *254*

0.00



Packaging

Memo

0.00

Packaging

10-1-14

(B) SP

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15 *MF*

MF 10-1-15

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NOTE: Date & initial all entries

Picklist Print

December 7, 2009 3:08:05 PM

Page 1

Work Order ID: 54302

Parent Item: D3766-1

Parent Item Name: Front Rail, LH


Comments:

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	56.1948	23.5175			
												
6061T6 RD TUBE 1.00 X .188W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

56.1947542

109041

1.03

112529

53.5647542

18101

1.6

M113511

8X

m.k

10/01/11

[Handwritten signature]

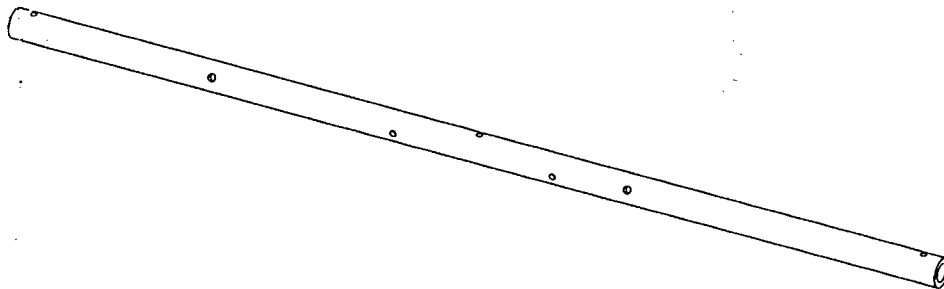
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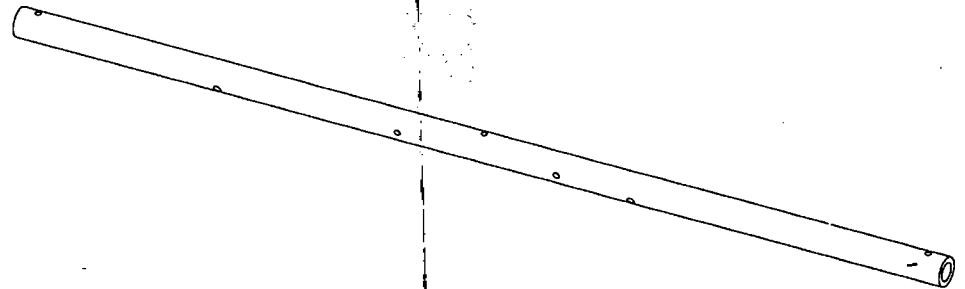
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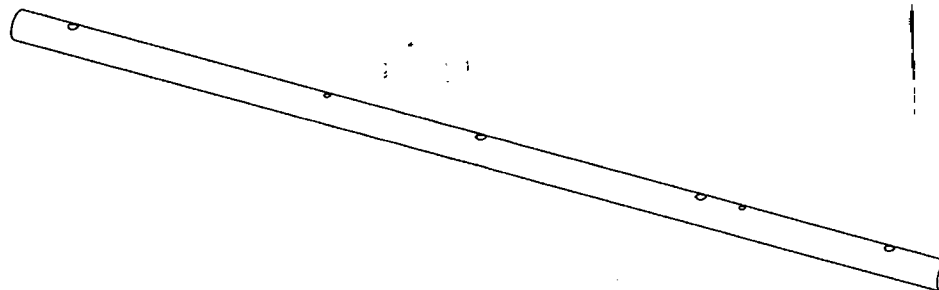
NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH



D3766-2 FRONT RAIL, RH



D3766-3 REAR RAIL

SHOP
RETU
ENCL
UNCONTROL
SUBJECT TO
WITHOUT
WORK
NO. 54302
09-12-7

RELEASED
08.07.10

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3766	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	RAIL	NTS
DATE	08.06.10	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

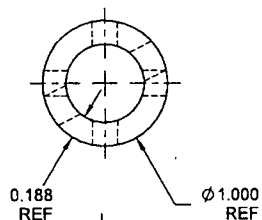
W/O:		WORK ORDER CHANGES					
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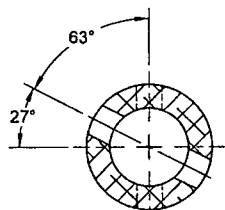
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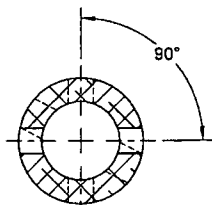
NOTE: Date & initial all entries



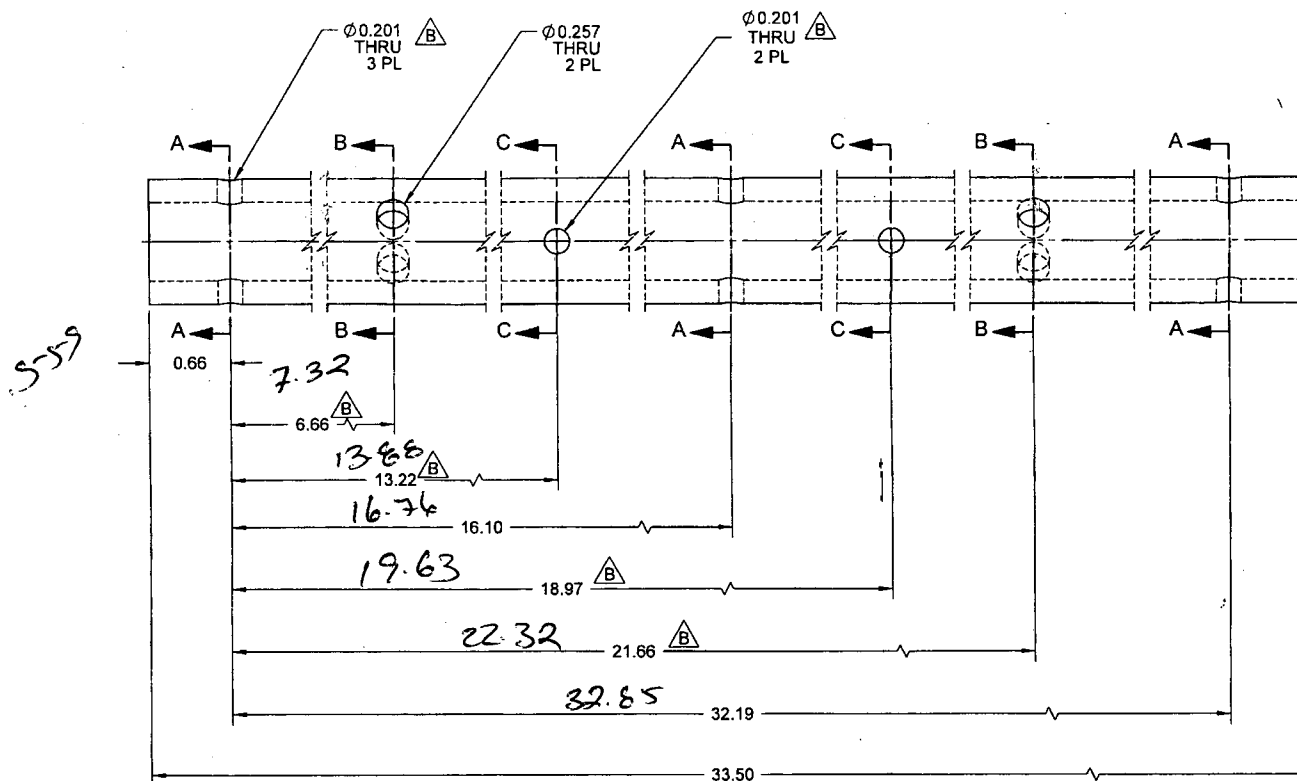
SECTION A-A



SECTION B-B



SECTION C-C



D3766-1 FRONT RAIL, LH

RELEASED
08-07-10

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3766	SHEET 2 OF 4
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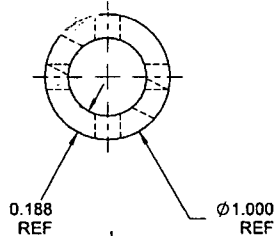
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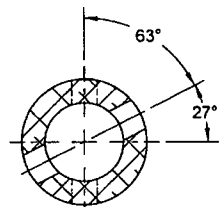
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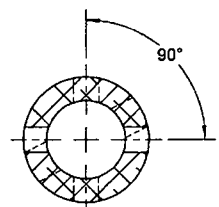
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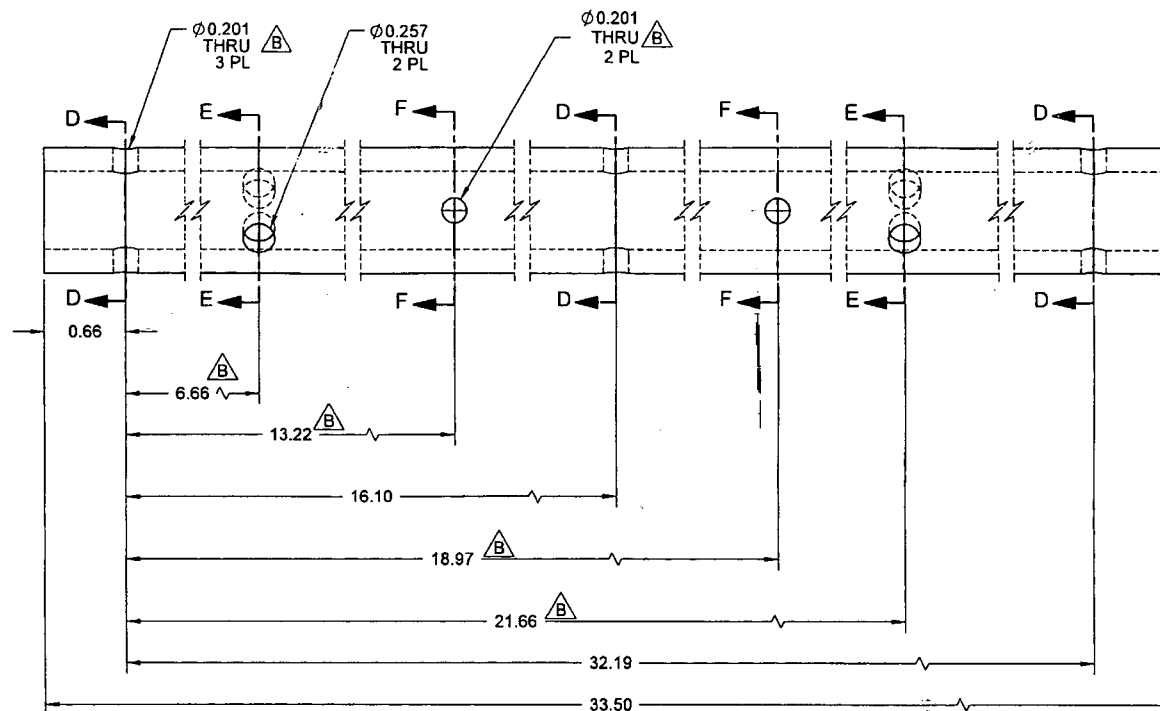
SECTION D-D



SECTION E-E



SECTION F-F



D3766-2 FRONT RAIL, RH

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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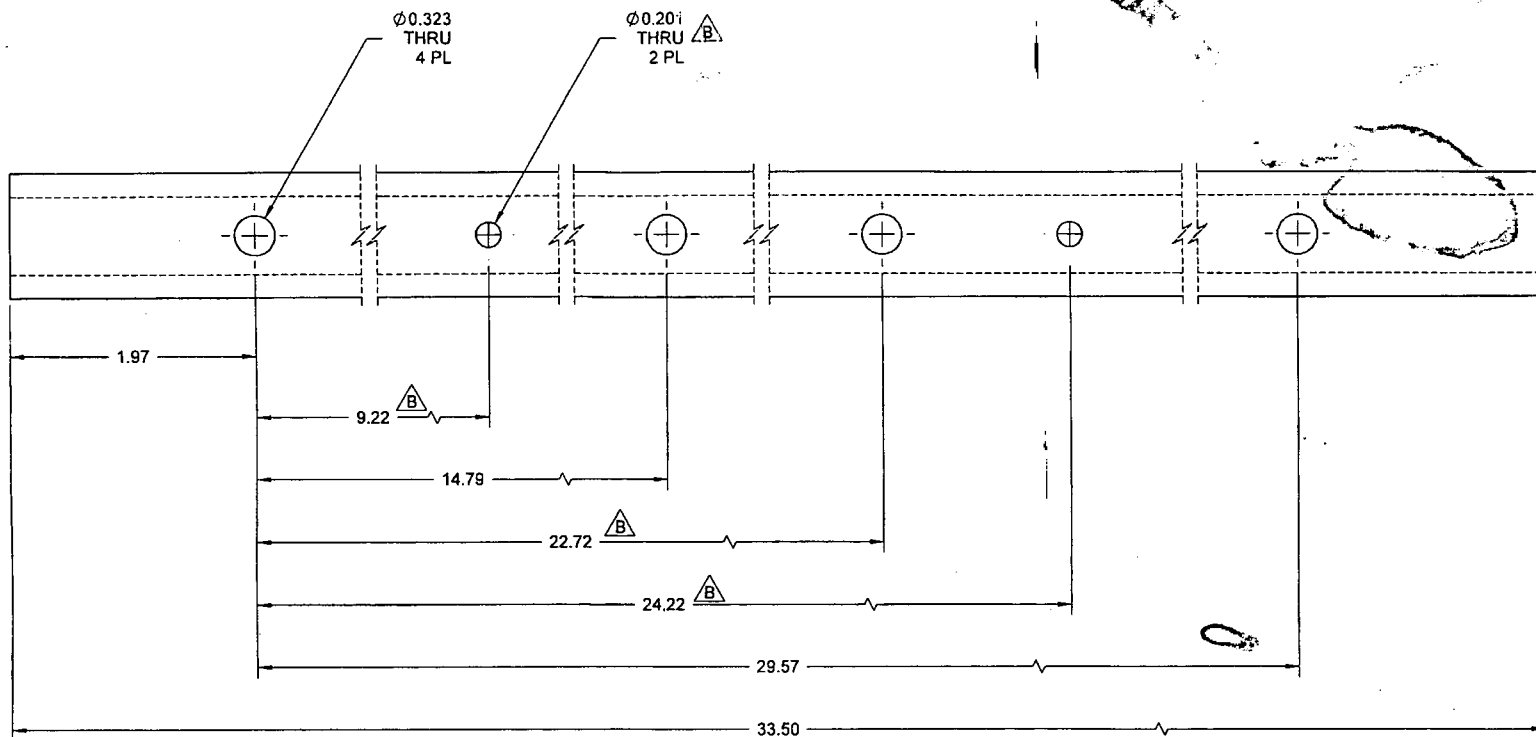
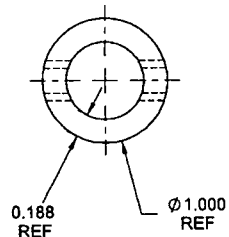
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3766-3 REAR RAIL

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. B
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8 7 6 5 4 3 2 1

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